

Work Order ID 128620

128620

Page 1

January-20-15 7:57:50 AM

Item ID: D3041-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 1/20/15 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 15-01-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3041	Rev C

100 0.00

100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut D2423 Extrusion: 1.250" Long

110 0.00

110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Check for cracks while loading into the machine
 Machine as per Folio FA153 and Dwg D3041
 DWG REV: _____
 FOLIO REV: _____

120 0.00

120 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00

Quality Control

Out source
Source P/O - 27263
Aluminum powder coat per Q51005

CL 15/01/29 30

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Item ID: D3041-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Clamp

Stop *NS2*

Start Date: 1/20/15 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/06/15 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

(30) 15-03-16 DAS
9
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

CY 15/01/29

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

Mask inside of 0.8120" diameter hole START TIME:
OVEN TEMPERATURE: FINISH
TIME:

CY 15/01/29

N/A

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January-20-15 7:57:50 AM

Item ID: D3041-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 1/20/15

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/06/15

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									DAS
QC	Memo	0.00				(30)	15.03.16		9 9-89
Quality Control									
170		0.00							
170	Small Fab								
Small Fab	Memo Remove Paint 0.00 Inside of the hole								DAS 36 9-89
Small Fab	1- Press D2611 bearing into lug as per Dwg D3041 using DT 9472								
	2- Stake bearing into place as per Dwg D3041 using DT9456								
	3-Touch up stake marks with white emeron paint								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									DAS
QC	Memo	0.00							38 9-89
Quality Control						(30)			APR 01 2015

MAR 20 2015

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January-20-15 7:57:50 AM

Item ID: D3041-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp
 Start Date: 1/20/15 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>S/S20</u>	0.00							
190						30	27		
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
2000									
QC	Memo	0.00							
Quality Control									

MS-4-7

Picklist Print

January-20-15 7:57:50 AM

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Work Order ID: 128620

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Parent Item: D3041-3

D3041-3

Parent Item Name: Clamp

Start Date: 1/20/15

Required Date: 2/06/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: A01.07.11New IssueSM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 *D2423* Lug Extrusion		Manufactured	No			170	f	0.0000	0.1042	3 4.042			
									**				
D2611 *D2611* Bearing		Manufactured	No			100	Each	48.0000	1	20 30			
									**				
												MAR 20 2015	

Location

ST008A

128963

108514

124478

ST12a

127926

Loc Qty

28

8

20

20

20

Loc Code

22

8

DAG
06
9-89

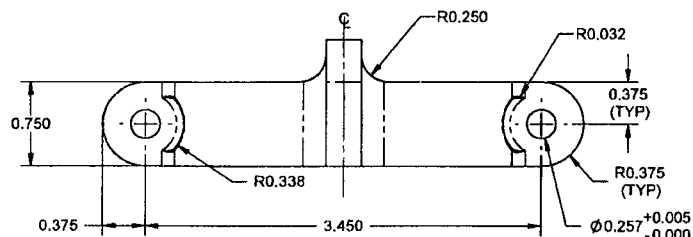
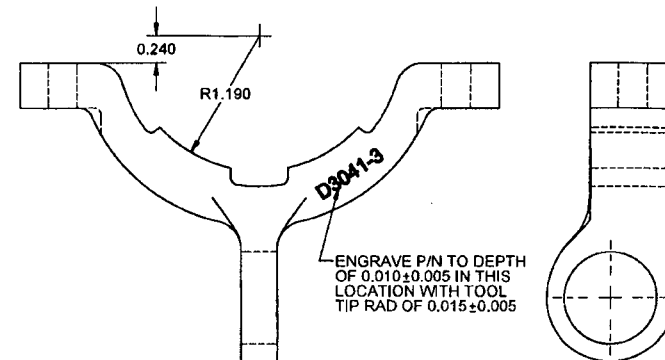
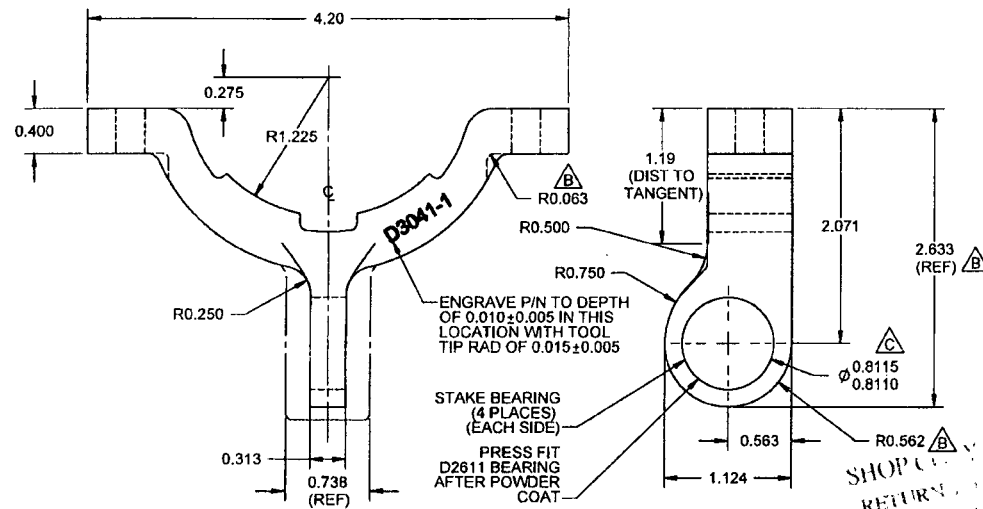
D 3041-3P

X 30

CX 15/04/07

(30)

MAR 02 2015



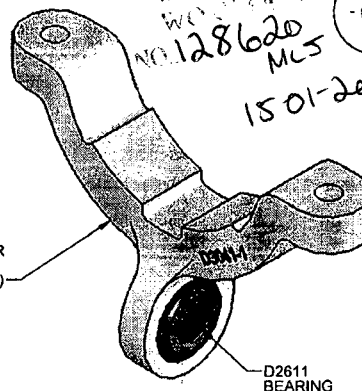
D3041-1 CLAMP

D3041-3 CLAMP
(SAME AS D3041-1 EXCEPT AS SHOWN)

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT C

D3041-1 CLAMP (SHOWN) OR D3041-3 CLAMP (NOT SHOWN)



DEO ATTACHED

RELEASED

06.11.17

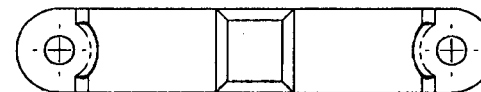
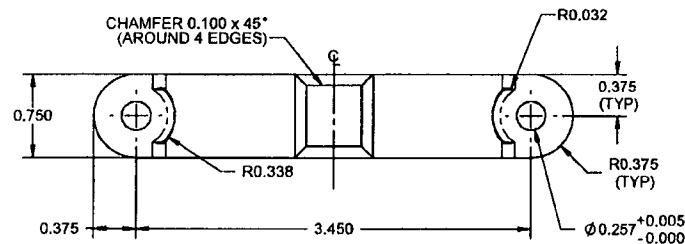
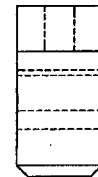
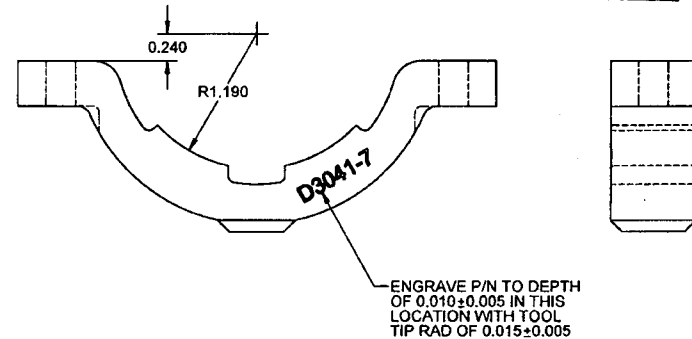
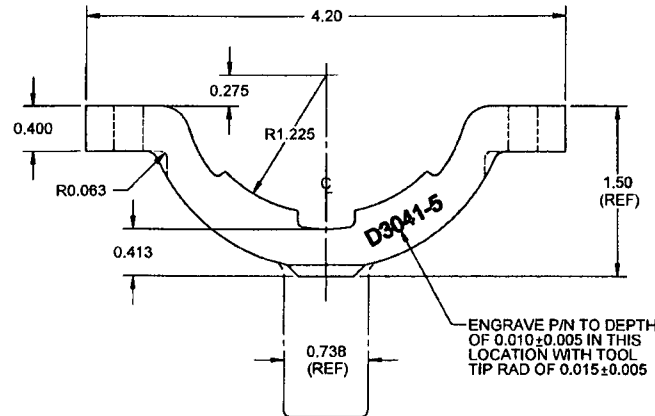
C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	06.10.18	DRAWING NO. D3041
		TITLE CLAMP
		REV. C
		SHEET 1 OF 2
		SCALE 1:1

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DEO ATTACHE

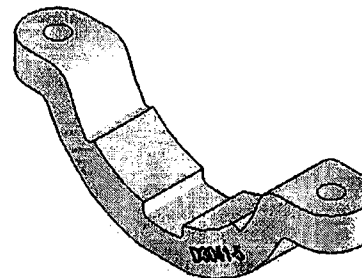
RELEASED

06.11.17



D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

D3041-5 CLAMP



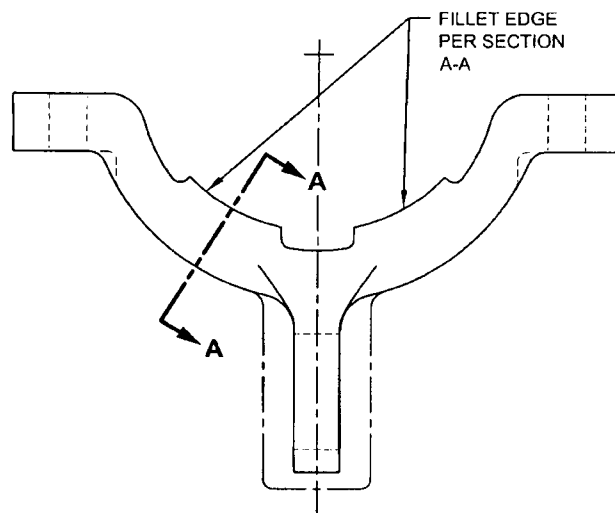
NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT ϕ

DESIGN 07	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 16	APPROVED 16	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP		SCALE 1:1
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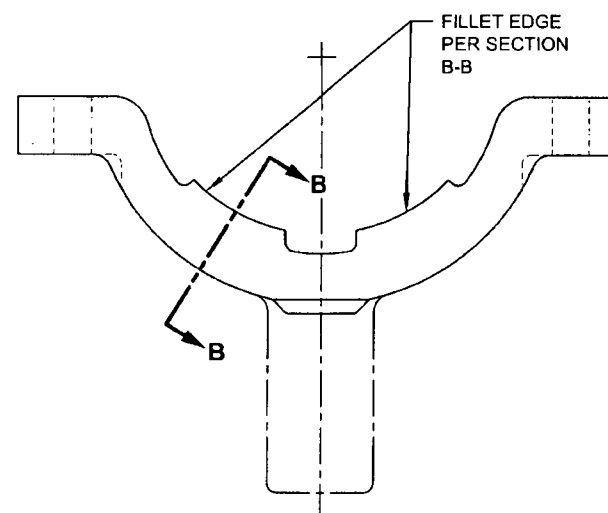
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13		DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



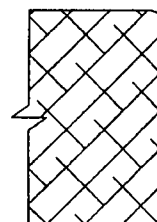
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07 MRP

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27263**

Purchase Order Date 1/29/2015

PO Print Date 4/7/2015

Page Number 1 of 3

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 10

Currency CAD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3041-1P	Clamp	2/24/2015 Yes 2/24/2015		50.00 Each	\$14.00	\$700.00
	AS PER DWG D3041 REV. C ALODINE & PAINT AS PER QSI005 B128623						
	Line Total:						\$700.00
2	D3041-3P	Clamp	2/24/2015 Yes 2/24/2015		30.00 ✓ Each CXL 15/04/10	\$14.00	\$420.00
	AS PER DWG D3041 REV. C ALODINE & PAINT AS PER QSI005 B128620						
	Line Total:						\$420.00

Note:

4/7/2015



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19842
Date: Feb 27, 2015
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 27263	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date: Feb 27, 2015

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp, as per drawing D3041 REV.C Alodine and paint as per QS1005 Date available February 24 2015	Each	50		50
D3041-3 Clamp, as per drawing D3041 REV.C Alodine and paint as QS1005 Date available February 24 2015	Each	30	30	
D3041-5 Clamp, as per drawing D3041 REV.C Alondine and paint as per QS1005 Date available March 3 2015	Each	50	50	
D3041-7 Clamp, as per drawing D3041 REV.C Alondine and paint as per QS1005 Date available March 3 2015	Each	30	30	
D4091-1 Lug, as per drawing D4091 Rev.A Alondine and paint as per QS1005 Date available March 3 2015	Each	30	30	
D2230-3 Mounting Lug, as per drawing D2230 REV.G Alondine and paint as per QS1005 Date available February 24 2015	Each	80	80	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

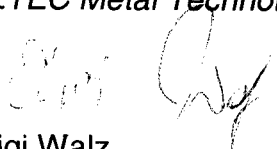
SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D3041-3	Clamp	27263
	MATERIAL: supplied by DART B127892		
	PAINT BATCH # 11116		
50	D3041-5	Clamp	27263
	MATERIAL: supplied by DART B127892		
	PAINT BATCH # 11112		
30	D3041-7	Clamp	27263
	MATERIAL: supplied by DART B115529		
	PAINT BATCH # 11116		
30	D4091-1	Lug	27263
	MATERIAL: supplied by DART B115529		
	PAINT BATCH # 11116		
80	D2230-3	Lug	27263
	MATERIAL: supplied by DART B115529		
	PAINT BATCH # 11112		

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, February 27, 2015